Tuesday, 11/29/2005 5:05:19 PM

User:

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

Type

S.O. No. : NIA

: 25014

Estimate Number

: 10480

P.O. Number

This Issue

: NIA

Prsht Rev.

: 11/29/2005

: NC

First Issue : 11/29/2005

Previous Run Written By

Checked & Approved By

Comment

: Est:C 03.04.14 Reformat; Incorporated D2292;

D2375-3-08-106; D2403 - D2417 KJ/RF

: SMALL /MED FAB

Part Number Drawing Number

Drawing Name

: D2410 D2410 REV. B : N/A

: ASPIRATOR ASSEMBLY

Project Number **Drawing Revision**

Material **Due Date**

: B

3

3

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: Insulation 48'of 3"ID*1/

1.0 D2375308



Comment: Qty.:

0.8333 f(s)/Unit

Total: 3.3332 f(s)

Insulation 48' of 3"ID*1/

Pick:

Qty 10.6"

Part Number D2375-3-08

Description Insulation

FF 06-10-30

2.0

D2403



Comment: Qty.:

1.0000 Each(s)/Unit Total:

4.0000 Each(s)

Outer Skin Pick:

Qty

1

Part Number D2403

Description Outer Skin

FF 06-10-30

3.0

D2404

Comment: Qty.:



1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Perforate Sheet, 0.125 Ho

Pick:

Qty Part Number D2404 1

Description Perforated Sheet

Batch $B21544 \times 2/B25063 \times 1$ support, 5052-H34

4.0

D2411

Pick: Qty

Valve support, 5052-H34



Comment: Qty.:

1.0000 Each(s)/Unit Total:

4.0000 Each(s)

Valve support, 5052-H34

Part Number

Description

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 11/29/2005 5:05:19 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: ASPIRATOR ASSEMBLY** Job Number: 25014 Part Number: D2410 Job Number: Seq. #: Machine Or Operation: Description: 1 D2411 Valve Mtg Angle 06-10-30 D2412 5.0 Comment: Qty.; 3.0692 sf(s) 0.7673 sf(s)/Unit Total: Insulation filter Pick: Qty Part Number Description 06-10-30 _3 110.5si D2412 Insulation Filter 6.0 D2413 Intake Weldmen Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Intake Weldment Pick: Part Number Qty Description FF 06-10-30 3 1 D2413 Intake Assembly 7.0 D2414 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) **Outlet Weldment** Pick: Qty Part Number Description FF 06-10-30 1 D2414 **Outlet Assembly** 8.0 D2416 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Mounting angle, 1x.625x. Pick: Qty. Part Number Description ₹1 D2416 Mounting Angle 9.0 D2417 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Mounting angle, 1x.625x. Pick: B26908x2/B21844-x1 Part Number Description Qty D2417 **Mounting Angle**

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 5:05:19 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: ASPIRATOR ASSEMBLY Job Number: 25014 Part Number: D2410 Job Number: Seq.#: Machine Or Operation: Description: 10.0 MS20470AD45 Rivet, Universal Head Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description MS20470AD4-5 Rivet 11.0 MS20600AD4W2 Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s) Rivet Pick: Qty Part Number Description Batch 4747 15 MS20600AD4W2 Rivet 3 06-10-30 (or CR9163-4-2) 12.0 MS20600AD4W3 Cherry Rivets Comment: Qty.: 8.0000 Each(s) 2.0000 Each(s)/Unit Total: Cherry Rivets Pick: Qty Part Number Description MS20600AD4W3 Rivet 06-10-30 3/0 (or CR9163-4-3) 13.0 MS20600AD4W4 Rivets Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s) Rivets Pick: Qty Part Number Description Batch MS20600AD4W4 Rivet 06-10-30 3 (or CR9163-4-4) 14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 770 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2410

Form: rprocess

Page 3

W/O:				WORK ORDER	CHANGES				April 1 to the second of the second	· ar · · · · · · · · · · · · · · · · · ·
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NCR:		W.	ORK OR	DER NON-CONFORMANCE	E (NCR)			
DATE	STEP	Description of NC Section A			Verification Section C	Approval Chief Eng	Approval QC Inspector	
06-10-31	14	7 extra ms 20600 AD 4 wy		scraped (Pin pulled out put riviting)	· ·		B	
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NOTE: Date & initial all entries

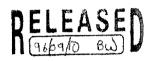
 Tuesday, 11/29/2005 5:05:19 PM User: , Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: ASPIRATOR ASSEMBLY Job Number: 25014 Part Number: D2410 Job Number: Seq. #: Machine Or Operation: Description: 15.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 16.0 POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3 ****Place masking tape on red anodize tube of flare section and access to interior of both ends.**** 17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT 18.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 19.0 DOCUMENT CONTROL Comment: DOCUMENT CON 1 Inspection Level 21 Job Completion

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PRE	PARED		DART AERO ACCESSORIES	INC
В.	Willia	ms	VICTORIA INTERNATIONAL AIRPORT, CANADA	1140
CHE	CKED	APPROVED		REV. A
B	ک	BW	D2410 SHEET	1 OF 2
DAT	E		TITLE	SCALE
 Αр	r. 6,	1995	206 ASPIRATOR ASSEMBLY	
Α		95.04.06	NEW ISSUE	
Ai	4	许 03.04.29	ADDED FLARE	·



QTY	Part No.	Description
Х	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	. MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS 20600 AD 4WZ	RIVET (CR9163-4-2)
7	MS 20600 AD4 W3	RIVET (CR9163-9-3)
12	MS 20600 AD 104	RIVET / (R9163-4-4)
8	MS20470AD4-5	Rivets

